

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
690 Walnut Ave.St. 150
Vallejo, CA 94592-1133
(707) 649-5453
(707) 649-5493

Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-021675**Date Inspected:** 24-Feb-2011**Project Name:** SAS Superstructure**OSM Arrival Time:** 1500**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 300**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** See Below**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG**Summary of Items Observed:**

Summary of Items Observed: On this date Caltrans OSM Quality Assurance (QA) Inspector, Mike Hasler was present during the times noted above for observations and testing relative to the work being performed.

Bay 8

This QA inspector performed a random observation for the OBG. During the observation performed it was noted that at Bay 8 ZPMC was in process of FCAW (ESAB) welding on bike path assembly BK004A8-062. ZPMC QC inspector Liu Chuan Gang was present at this time of this observation and informed this QA inspector of the work that is in process and identified Liu Fa Wen as the CWI. It was stated that ZPMC had 1 welder and identified the welder by ZPMC welder identification number appointed to then by ZPMC. This QA inspector verified this information for the following location;

Weld- BK004A8-062-072, 073

WPS-B-T-2132-ESAB

Welder-219414

2F/ FCAW

Bay 3

This QA inspector performed a random observation for the OBG. During the observation performed it was noted that at Bay 3 ZPMC was in process of FCAW (ESAB) welding on Architectural Housing subassembly AH3150. ZPMC CWI inspector Wang Liang was present at this time of this observation and informed this QA inspector of the work that is in process. It was stated that ZPMC had 1 welder and identified the welder by ZPMC welder

WELDING INSPECTION REPORT

(Continued Page 2 of 5)

identification number appointed to then by ZPMC. This QA inspector verified this information for the following location;

Weld- AH3150-003
WPS-B-T-2231-ESAB
Welder-206623
1G/CJP/FCAW

This QA inspector observed ZPMC SMAW welding in process on Architectural Housing subassembly AH3151 and AH3152. ZPMC QC inspector Zhang Ya Xu was present at this time of this observation and informed this QA inspector of the work that is in process. It was stated that ZPMC welder identified by ZPMC welder identification number appointed to then by ZPMC was welding VT weld repairs. This QA inspector verified this information for the following location;

AH3151 & AH3152
WPS-B-P-2113
Welder-058102
3F/SMAW/VT Repairs

Bay 1

This QA inspector performed a random observation for the OBG. During the observation performed it was noted that at Bay 1 ZPMC was in process of FCAW (ESAB) welding on traveler rail assembly. ZPMC CWI inspector Tian Lei was present at this time of this observation and informed this QA inspector of the work that is in process. It was stated that ZPMC had 3 welders performing weld repairs and identified the welders by ZPMC welder identification number appointed to then by ZPMC. This QA inspector verified this information for the following location;

Weld- 20TR2-037-009, 013
WPS-B-T-2231-ESAB
Welder-204342
1G/CJP/FCAW

Weld- 20TR2-037-009, 013
WPS-B-T-2231-ESAB
Welder-053609
1G/CJP/FCAW

Weld- 20TR2-037-009, 013
WPS-B-T-2231-ESAB
Welder-217185
1G/CJP/FCAW

Bay 10

This QA inspector performed a random observation for the OBG. During the observation performed it was noted

WELDING INSPECTION REPORT

(Continued Page 3 of 5)

that at Bay 10 ZPMC was in process of FCAW (ESAB) welding on Bike Path assemblies. ZPMC QC inspector Li Jun was present at this time of this observation and informed this QA inspector of the work that is in process and identified Zhang Huang as the CWI. It was stated that ZPMC had 4 welders and identified the welders by ZPMC welder identification number appointed to then by ZPMC. This QA inspector verified this information for the following location;

Weld-BK008A3-001-005, 009

WPS-B-T-2133-ESAB

Welder-040434

3G/FCAW/PJP

Weld-BK008A5-001-004, 007

WPS-B-T-2133-ESAB

Welder-053869

3G/FCAW/PJP

Weld-BK014A6-001-068, 069

WPS-B-P-2112

Welder-057239

2F/SMAW/Tack Weld

Weld-BK009A4-001-074 ~ 081

WPS-B-T-2133-ESAB

Welder-040333

3F/FCAW

This QA inspector observed during the observation that at Bay 10 ZPMC was in process of SMAW welding on traveler rail and bike path cantilever beam. ZPMC QC Zhu Feng was present at this time of this observation and informed this QA inspector of the work that is in process. It was stated that ZPMC had 6 welders and identified the welders by ZPMC welder identification number appointed to then by ZPMC. This QA inspector verified this information for the following location;

Weld- 20TR2-030-011

WPS-B-P-2211-TC-U5b

Welder-057258, 052930, 002493, 0500363, 044511

1G/SMAW/CJP

Weld- BK16B-001-005

WPS-B-P-2212-TC-U4b

Welder-216001

2G/SMAW/CJP

Bay 11

This QA inspector observed ZPMC in process of SMAW welding on traveler rail assembly 20TR2-034. ZPMC

WELDING INSPECTION REPORT

(Continued Page 4 of 5)

QC inspector Wang Chuang Xin was present at this time of this observation and informed this QA inspector of the work that is in process and identified Zhang Huang as the CWI. It was stated that ZPMC had 2 welders and identified the welders by ZPMC welder identification number appointed to then by ZPMC. This QA inspector verified this information for the following location;

Weld- 20TR2-034-009
WPS-B-P-2211-TC-U5b
Welder- 044551
1G/SMAW/CJP

Weld- 20TR2-034-017
WPS-B-P-2211-TC-U5b
Welder- 044541
1G/SMAW/CJP

Trial Assembly

This QA inspector performed a random observation for the OBG. During the observation performed it was noted that at Trial Assembly ZPMC was in process of welding on Lift 12. ZPMC QC inspector Wang Zhu was present at this time of this observation and informed this QA inspector of the work that is in process and identified Gu Kong Jian as the CWI. It was stated that ZPMC had 2 welders and identified the welders by ZPMC welder identification number appointed to then by ZPMC. This QA inspector verified this information for the following location;

CWR2811
Weld- OBE12C-001
WPS-345-FCAW-1G-FCAW (ESAB)-Repair-FCM
Welder-047353
1G/FCAW/CJP

Weld- FB3039-007-013 (FS)
WPS-B-P-2144-FCM-1
Welder-040403
4F/SMAW

This QA inspector observed ZPMC personnel performing Heat Straightening on CB17 crossbeam. ZPMC QC He Yang Bing was present at this time of this observation and informed this QA inspector of the work that is in process. ZPMC QC inspector stated personnel performing Heat Straightening (HSR1-B-10127) top plate DP3037, DP3036, DP3035, DP3034, CB3001-017-001, 002. QA reviewed the procedure and observed that heat is being applied per heat straightening procedure requirements.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.

Summary of Conversations:

WELDING INSPECTION REPORT

(Continued Page 5 of 5)

“As noted within the contents of this report.”

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact James Devey 1500026784, who represents the Office of Structural Materials for your project.

Inspected By:	Hasler, Mike
----------------------	--------------

Quality Assurance Inspector

Reviewed By:	Riley, Ken
---------------------	------------

QA Reviewer
